

# Work Order ID 69842

Friday, May 20, 2011 9:25:29 AM

Page 1

Item ID: D4170-3

Accept

Setup Start

Revision ID:

Stop

Item Name: Bushing

Start Date: 5/20/2011 Start Qty: 30.00

Required Date: 5/23/2011 Req'd Qty: 30.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4170

B

100

0.00



Hardinge

Hardinge CNC Lathe Small

Hardinge CNC LATHE SMALL

Memo

Machine as per Folio FA889

FOLIO REV: U/A

DWG REV: B

DEBURR

0.00

110

0.00



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Handwritten signature

Handwritten date: 11/5/20

Handwritten: 25 and a circled X

Handwritten: 25 and a circled X

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Page 2

Item ID: D4170-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Bushing

Start Date: 5/20/2011 Start Qty: 30.00



Cust Item ID:

Required Date: 5/23/2011 Req'd Qty: 30.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool # Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

*QC 10-5-20*

*25*

125

0.00



Skidtubes

Memo

0.00

Skidtubes

1- clean crossbolt spacer with ultra bright aluminum cleaner before storing.

*WLAS*

130

Identify as per dwg & Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

0.00

Packaging

\*\*\*STOCK IN SKIDTUBE CELL\*\*\*

*4/10/20 25*

**Work Order ID 69842**

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Page 3

Item ID: D4170-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Bushing

Start Date: 5/20/2011 Start Qty: 30.00



Cust Item ID:

Required Date: 5/23/2011 Req'd Qty: 30.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

OK 4/05/20

4/6/05.20

# Picklist Print

Friday, May 20, 2011 9:25:27 AM

Page 1

Work Order ID: 69842

Parent Item: D4170-3

Parent Item Name: Bushing



Start Date: 5/20/2011

Required Date: 5/23/2011

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP REV:A NEW ISSUE 10-10-28 JLM VERIFIED BY:DD IPP  
Rev:A 10.11.02 as per revB DD ver:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6R0.500		Purchased	No			100	f	93.5850	0.275	8.684211			
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6061-T6 Round Bar .500"



2A 10/5/20

Location

Loc Qty

Loc Code

MAT012

93.585

114488

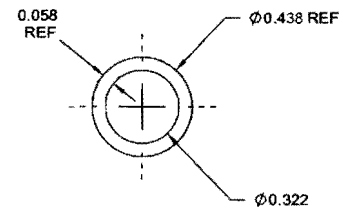
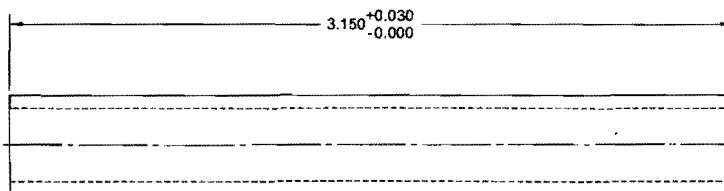
4.605

117379

88.98

6.842





**D4170-3 SPACER**

**NOTES:**

1) MATERIAL: 6061-T6 ROUND BAR,  $\phi 7/16$  OD  
PER QQ-A-225/8, QQ-A-200/8, ASTM B211, OR ASTM B221  
REF DART SPEC. M6061T6R0.438

OR

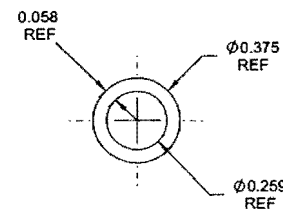
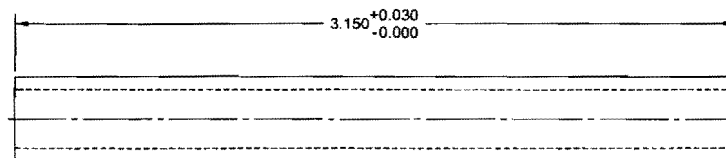
6061-T6 OR 6061-T62 TUBING,  $\phi 7/16$  OD X 0.058 WALL  
PER WW-T-700/6, AMS 4080, AMS 4082, QQ-A-200/8, OR QQ-A-225/8  
REF DART SPEC. M6061T6T0.438W.058

- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01lbs

**RELEASE**  
2010-11-01

DESIGN	SC	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	JP	PORT HADLOCK, WA	
CHECKED	JP	DRAWING NO.	REV. B
MFG. APPR.	JP	D4170	SHEET 2 OF 2
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	SPACER	NTS
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69842



# **D4170-1 SPACER**

**RELEASED**  
2010-11-01

## **NOTES:**

- 1) MATERIAL: 6061-T6 OR 6061-T62 TUBING,  $\phi 3/8$  OD X 3.058 WALL  
PER WW-T-700/8, AMS 4080, AMS 4082, QQ-A-200/8, OR QQ-A-225/8  
REF DART SPEC. M6061T6T0.375W.058
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01lbs

B	ADD-3 (SHEET 2)	CP	10.10.25
A	NEW ISSUE	SC	10.07.22
REV.	DESCRIPTION	BY	DATE
DESIGN	SC	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	JP	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4170	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		SPACER	NTS
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